












Date: Monday, 1/14/2008 2:37:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36755	
Estimate Number : 12105	
P.O. Number :	Part Number : D32011
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D3201 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33946	Material :
Written By :	Due Date : 2/5/2008 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A Removed from 9 Digit 06-01-25 JLM Est Rev:B Now on Waterjet 06-08-14 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S040 2024-T3 .040 sheet
 <i>lb</i> 	
Comment: Qty.: 0.2898 sf(s)/Unit Total : 11.5920 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3201-1 Batch: <i>106272</i> <i>LB 8-1-18</i>	
2.0	WATER JET FLOW WATER JET
 	
Comment: FLOW WATER JET 1-Cut as per Dwg D3201 Dwg Rev: <i>B</i> <i>LB 8-1-18</i> <i>(43)</i> Prog Rev: <i>B</i> 2-Deburr if necessary <i>LB 8-1-18</i>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
 <i>LB 8-1-18</i> 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
 	
Comment: SECOND CHECK <i>08/01/21</i> <i>(43)</i>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack <i>N/A</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 36755

Part Number: D32011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

08-01-21

X43

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H

08/01/21

43X

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5772

8/01/21

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.22
JF

Job Completion



U 08-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

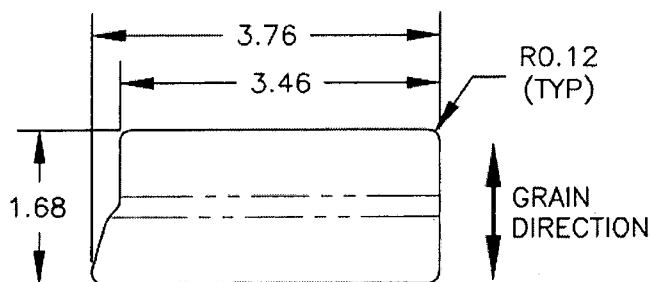
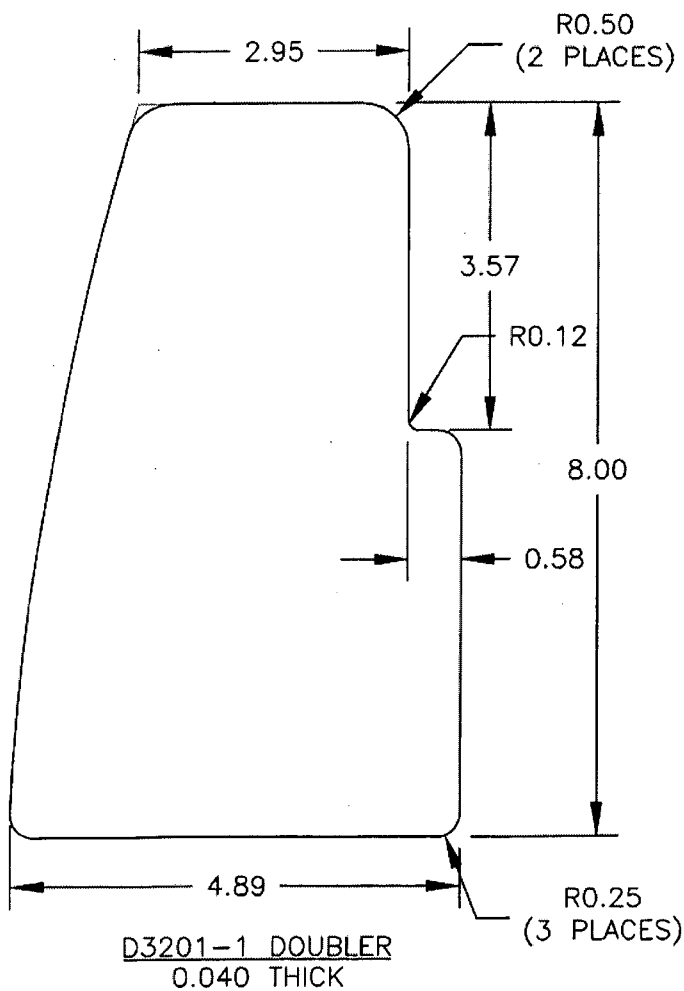
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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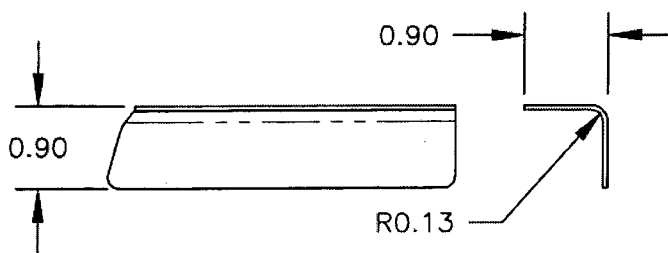


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14



D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 36755

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